

Work Order ID 71990



Page 1

Friday, July 15, 2011 8:38:40 AM

Item ID: D412-630-031

Accept



Setup Start



Revision ID:

Stop



Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 7-07-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-630 bluefile & type labels per PPP412-630-031 CHG003

8 w/01/13

8 w/01/13 11-9-12 (2)

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Assemble as per dwg D412-630 p.17

ensure tension to retract step is 11 to 18 lbs before installing lockwire.

8 w/01/13 11-9-12 (2)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

***ensure tension to retract step is 11 to 18 lbs ***

8 w/01/13

8 w/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Packaging Packaging	Pick Kit Memo	0.00 0.00				11/9/12		5/12	
140 QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00		5/10/13		82 44			
150 Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-630-031 Location: <u>31</u> PPP Rev: <u>31</u>	0.00 0.00				11/9/13		5	20

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Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14
ME
11-09-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 71990

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019,no chg EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 NUT		Purchased	No			130	Each	76.0000	1	2			
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST324								76					
					118078			26					
					118112			50					
AN310-5 NUT		Purchased	No			130	Each	42.0000	2				
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
ST324								42					
					114830			12					
					118112			30					
AN3C5A Bolt		Purchased	No			130	Each	1,183.000	3				
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
FP-A								7					
					115835			7					
ST350								1176					
					116419			28					
					116549			42					
					117343			500					
					117764			300					
					117872			306					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 2

Work Order ID: 71990

Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

AN44-C12

Purchased

No

130

Each

19.0000



eyebolt

Location

Loc Qty

Loc Code

ST362

19

117616

19

AN4C15

Purchased

No

130

Each

17.0000



BOLT

Location

Loc Qty

Loc Code

ST358

17

117764

7

118091

10

AN5C11

Purchased

No

130

Each

29.0000



BOLT

Location

Loc Qty

Loc Code

ST337

29

114801

29

AN5C15

Purchased

No

130

Each

23.0000



BOLT

Location

Loc Qty

Loc Code

ST338

23

114669

3

117616

20

AN960C10

NAS1149C0363
R

Purchased

No

130

Each

0.0000



WASHER



1114742 11/9/11 (2)

Friday, July 15, 2011 8:38:48 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

AN960C516

Purchased No

130 Each

27.0000

1

2

WASHER

Location

Loc Qty

Loc Code

ST347

27

102842

27

Manufactured No

130 Each

16.0000

1

D3454-1

Bushing

Location

Loc Qty

Loc Code

ST054

16

58555

16

Manufactured No

130 Each

22.0000

2

D3454-3

Bushing

Location

Loc Qty

Loc Code

ST058

22

56420

2

68467

20

Manufactured No

130 Each

24.0000

2

D3454-5

Bushing

Location

Loc Qty

Loc Code

ST054

24

68468

4

70527

20

Friday, July 15, 2011 8:38:48 AM

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Page 3

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

D3455-1 Manufactured No 130 Each 15.0000

S
72
Spacer

4 8 7x
B72133 SL

Location Loc Qty Loc Code

ST054 15

68469 1

70529 14

lx

D3455-3 Manufactured No 130 Each 13.0000

S
72
Spacer

2 4
B72163 SL

Location Loc Qty Loc Code

ST054 13

68470 13

D3462-041 Manufactured No 130 Each 1.0000

S
72
LH
Bracket Assembly

1 2
B72030 SL

Location Loc Qty Loc Code

ST198A 1

69947 1

MS21043-3 Purchased No 130 Each 872.0000

S
72
Nut

3 6
11/1/88 SL (2)

Location Loc Qty Loc Code

FG 72

103691 72

ST301 800

112314 65

118077 735

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item: D412-630-031

Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

MS24665-227

Purchased

No

130

Each

115.0000



COTTER PIN

Location

Loc Qty

Loc Code

GA

97

111041

97

ST309

18

113845

18

MS24665-229

Purchased

No

130

Each

315.0000



COTTER PIN

Location

Loc Qty

Loc Code

GA

200

118234

200

ST309

115

111041

115

NAS1515H5

Purchased

No

130

Each

163.0000



Washer

Location

Loc Qty

Loc Code

FG

40

103286

20

103691

20

ST277

123

103286

100

109430

23

Friday, July 15, 2011 8:38:49 AM

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Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00

D3463-041



Step Weldment Assembly

Manufactured No

110 Each 2.0000

1 2



EP 11/09/07

Location

Loc Qty

Loc Code

ST494

2

70532

2

B72201 (2x)

D3443-043



Strut Weldment Assembly

Manufactured No

110 Each 0.0000

1 2



B70525 (2x)

EP 11/09/07

D3443-041



Strut Weldment Assembly

Manufactured No

110 Each 0.0000

1 2



B71138 (2x)

EP 11/09/07

D3443-9



Pin

Manufactured No

110 Each 2.0000

2 4



EP 11/09/07

Location

Loc Qty

Loc Code

ST053

2

70526

2

B72029 (4x)

D3454-7



Bushing

Manufactured No

110 Each 24.0000

2 4



EP 11/09/07

Location

Loc Qty

Loc Code

ST058

24

70528

24

4

Friday, July 15, 2011 8:38:49 AM

Shop Packet Print

Page 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00



Spacer

Manufactured No

110 Each

15.0000

2

4

Location

Loc Qty

Loc Code

ST054

15

68469

1

70529

14



Washer

Manufactured No

110 Each

14.0000

1

2

Location

Loc Qty

Loc Code

ST054

14

46134

14



SS Bolt

Purchased No

110 Each

24.0000

2

4

Location

Loc Qty

Loc Code

ST357

24

117616

14

118131

10



BOLT

Purchased No

110 Each

35.0000

1

2

Location

Loc Qty

Loc Code

ST357

25

117688

25

ST358

10

114669

10

EP 11/09/07

B72133
(42)

EP 11/09/07

2
EP 11/09/07

4
EP 11/09/07

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Pilot/Co-Pilot Step, LH (Folding)

Start Date: 7/15/2011

Required Date: 7/29/2011

Start Qty: 2.00

Required Qty: 2.00



Purchased No

110 Each

76.0000

1

2



EP 11/09/07

Location

Loc Qty

Loc Code

ST324

76

118078

26

118112

50

2



Purchased No

110 Each

37.0000

1

2



EP 11/09/07

Location

Loc Qty

Loc Code

ST324

37

114784

37

2



Purchased No

110 Each

115.0000

1

2



EP 11/09/07

Location

Loc Qty

Loc Code

GA

97

111041

97

ST309

18

113845

18

2



Purchased No

110 Each

180.0000

1

2



EP 11/09/07

Location

Loc Qty

Loc Code

ST357

180

117460

180

2

Friday, July 15, 2011 8:38:49 AM

Shop Packet Print

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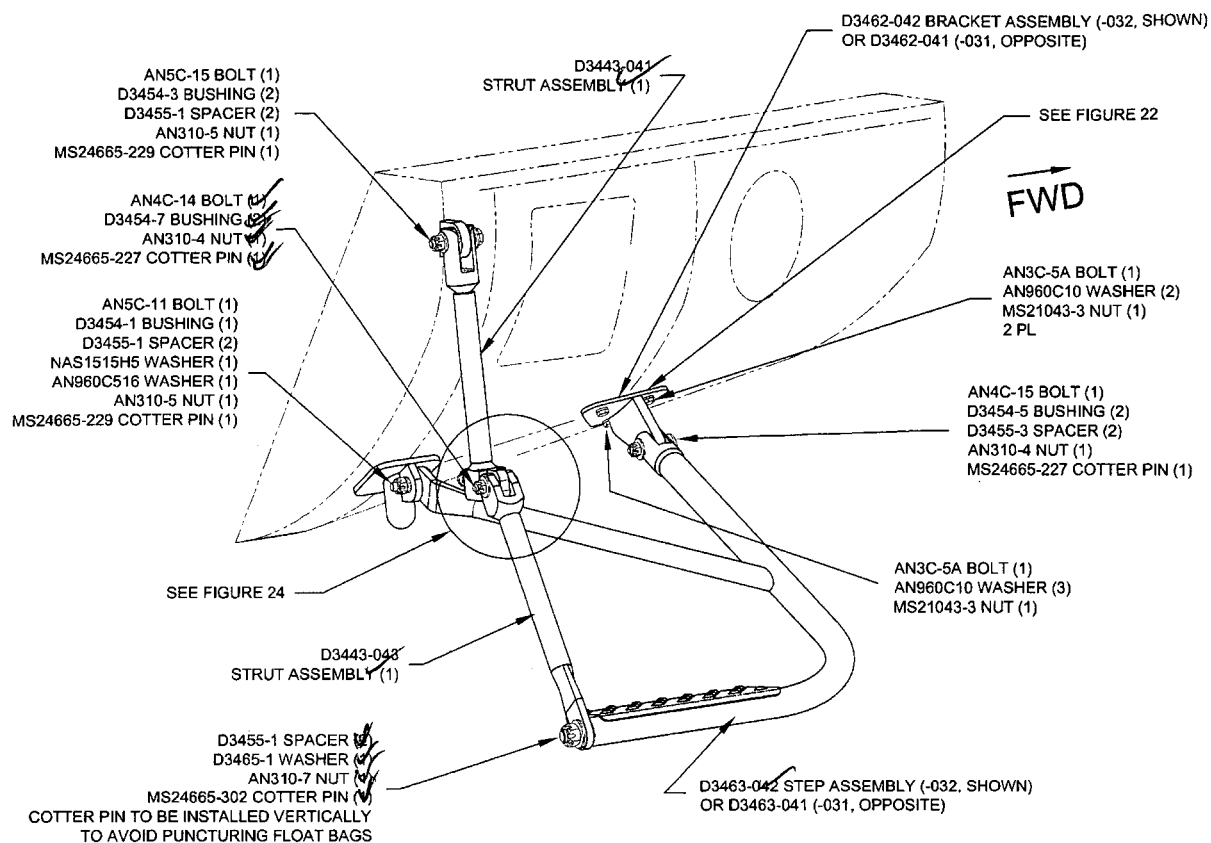
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

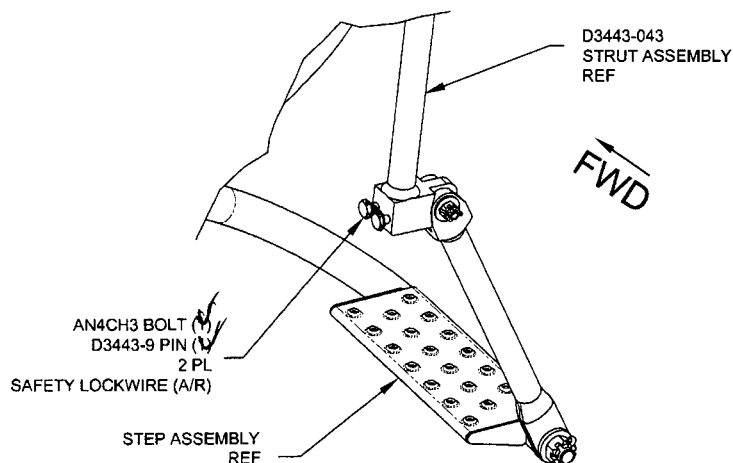
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



**FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**



**FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)**

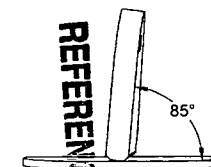
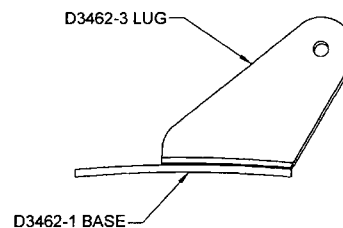
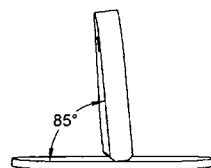
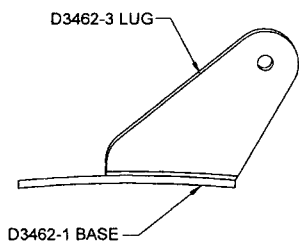
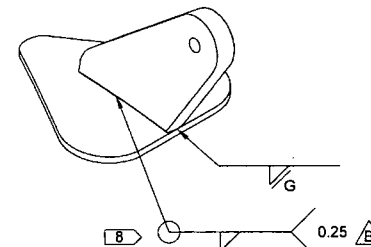
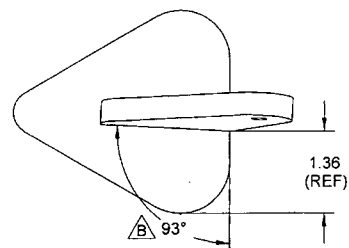
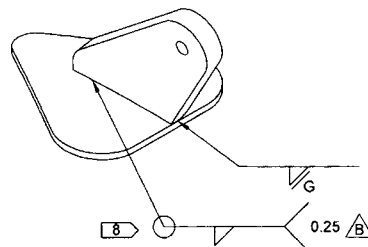
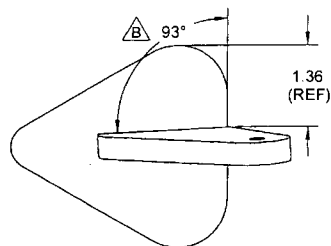
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Revision: **M**
Date: 08.12.12

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER (-2)
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1	1	D3463-041	STEP ASSEMBLY
1	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT (1)
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN (1)
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP



REFERENCE ONLY

D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	IP, RF, DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	IP, RF, DC		
CHECKED	IP, RF, DC	DRAWING NO.	REV. C
MFG. APPR.	IP, RF, DC	D3462	SHEET 1 OF 2
APPROVED	IP, RF, DC	TITLE	SCALE
DE APPR.	IP, RF, DC	BRACKET ASSEMBLY	1:2
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